

Work Order ID 51654

August 27, 2009 8:39:48 AM



Page 1

Item ID: D3535-37 *61*

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearshoe

Start Date: 8/27/09

Start Qty: 10.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *RL mfs*

Date: *09-8-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 240

1-Cut as per Dwg D3535 11Dwg Rev: *B* 11Prog Rev: *B* 12-
Deburr if necessary

B 9-10-7

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-10-7

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

278 07/10/07

(F13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51654

August 27, 2009 8:39:48 AM

Page 2

Item ID: D3535-37

Accept

Revision ID: B

Item Name: Wearshoe

Start Date: 8/27/09

Start Qty: 10.00

Required Date: 9/11/09

Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. 112-Identify as D3535-37

0.00

0.00

SB 09/10/07

13

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SB 09/10/08

13

4

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

11:00

FINISH TIME:

OVEN TEMPERATURE:

11:30

0.00

0.00

BL 09-10-8

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51654

August 27, 2009 8:39:48 AM

Page 3

Item ID: D3535-37

Accept

Revision ID: B

Item Name: Wearshoe

Start Date: 8/27/09

Start Qty: 10.00

Required Date: 9/11/09

Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

us

09/10/08

13

0

170



Packaging

Packaging

Identify as per dwg & Stock Location: FP-18

Memo

0.00

0.00

us

09/10/08

13

0

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/10/13

us 09/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:39:48 AM

Page 1

Work Order ID: 51654



Parent Item: D3535-37RevB



Parent Item Name: Wearshoe

Start Date: 8/27/09

Required Date: 9/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	63.3940	8.3737	10.8858		



304/316 .040 Sheet

HB 9-10-7

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	63.39404737	
110076	31.73	
111571	31.6640474	

111571

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51654
Description: WEAR SHEET		Part Number: D3535-37
Inspection Dwg: D3535-37 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	± .005 - .021	.188	X			
300 X 300	± .010	301 X 302	X			
1.885	± .010	1.891	X			
2.000	± .010	2.000	X			
4.750	± .010	4.750	X			
9.500	± .010	9.500	X			
14.250	± .010	14.250	X			
17.750	± .010	17.750	X			
22.500	± .010	22.500	X			
27.250	± .010	27.250	X			
30.750	± .010	30.750	X			
6.00	± .030	6.00	X			
8.00	± .030	8.00	X			
16.00	± .030	16.00	X			
21.00	± .030	21.00	X			
.040	± .010	.037	X			

Measured by: RB	Audited by: JF	Prototype Approval: N/A
Date: 9-10-07	Date: 09/10/07	Date: N/A

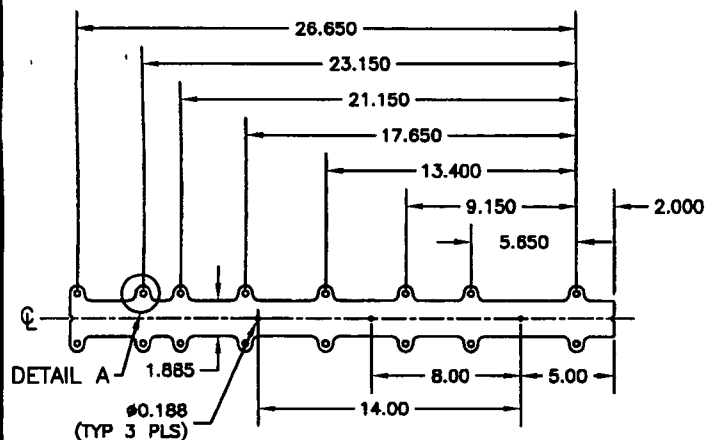
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

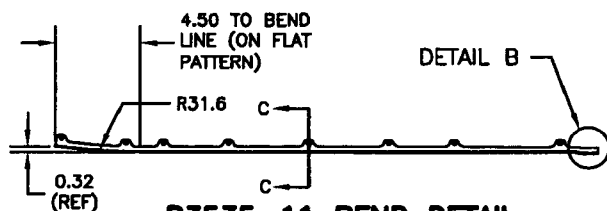
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07.04.24

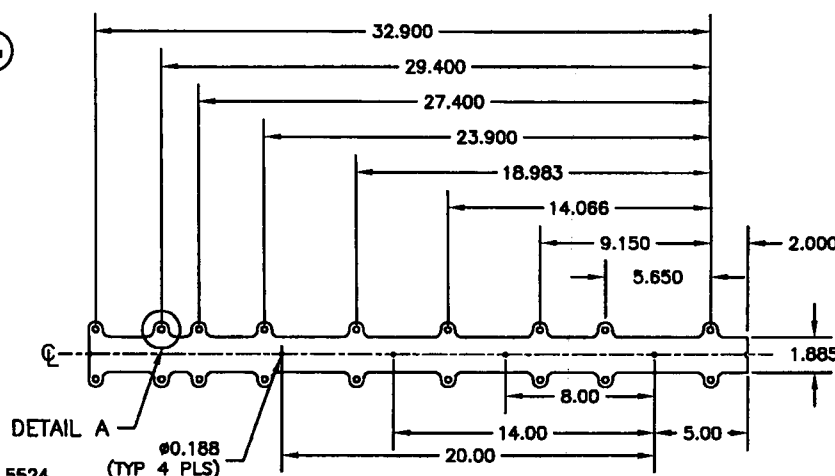
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NO. 51654



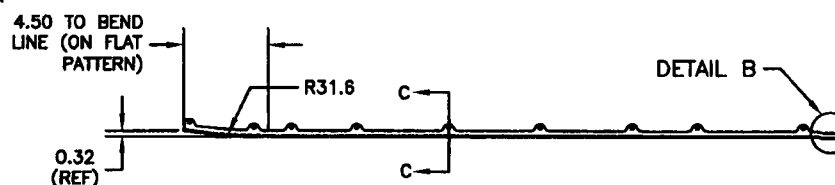
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

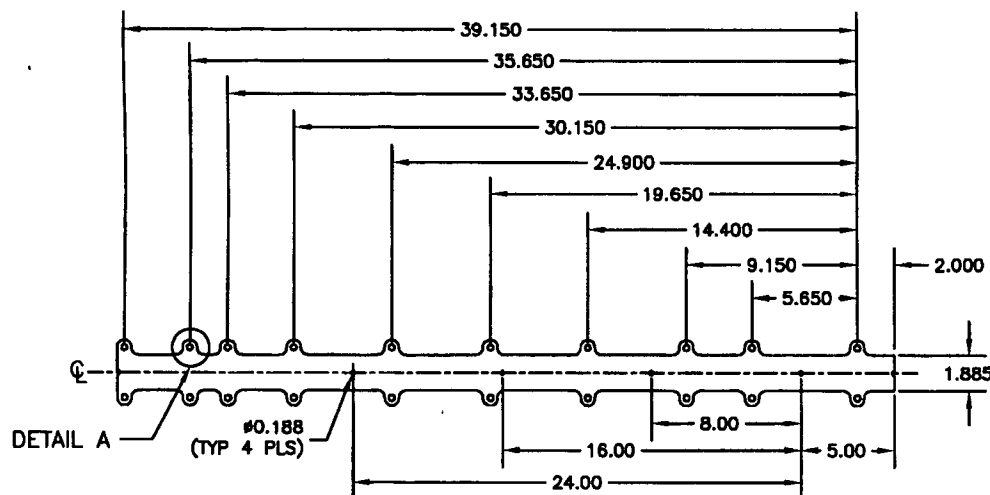
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PH	PH	D3535
DATE	TITLE	SCALE
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A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

DART

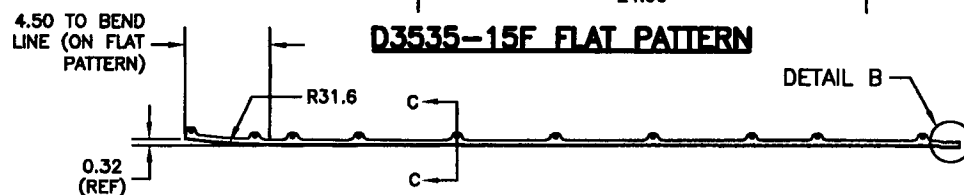
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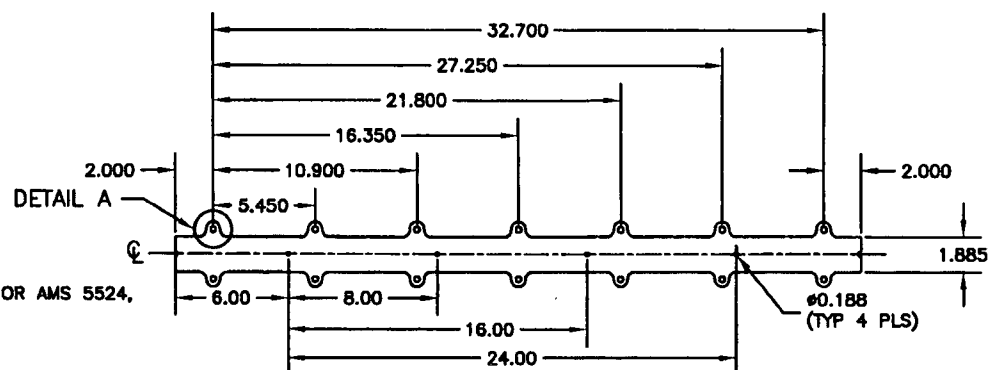
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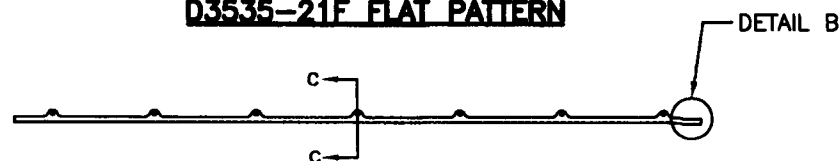
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

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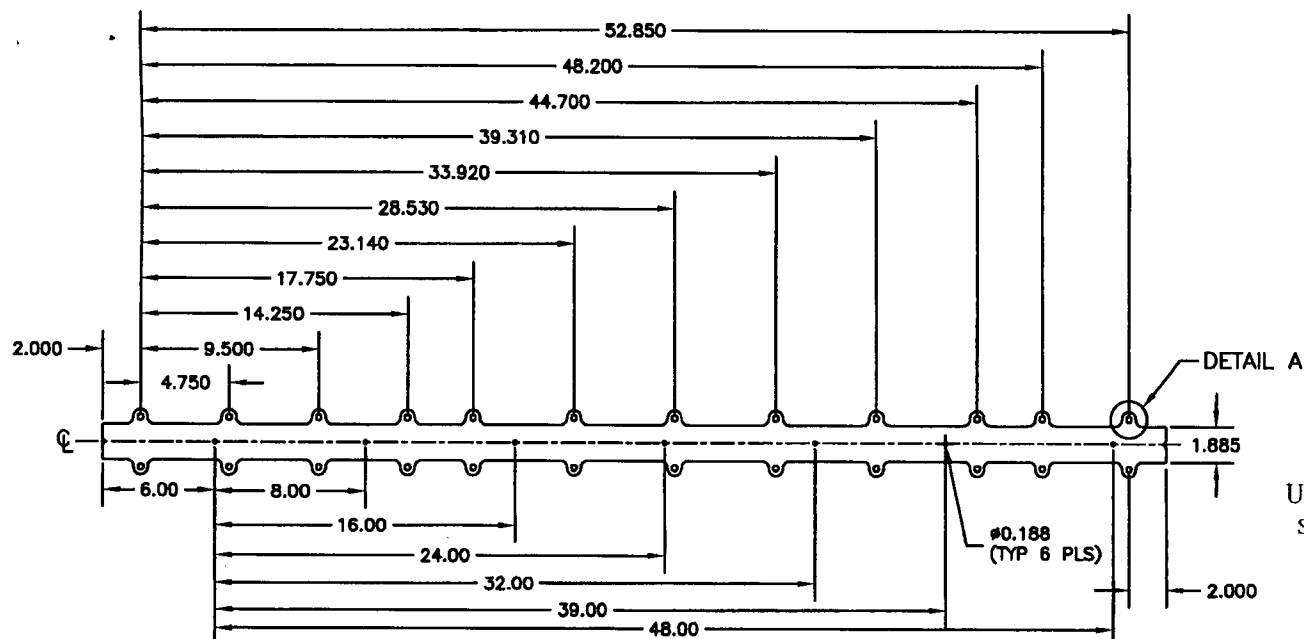
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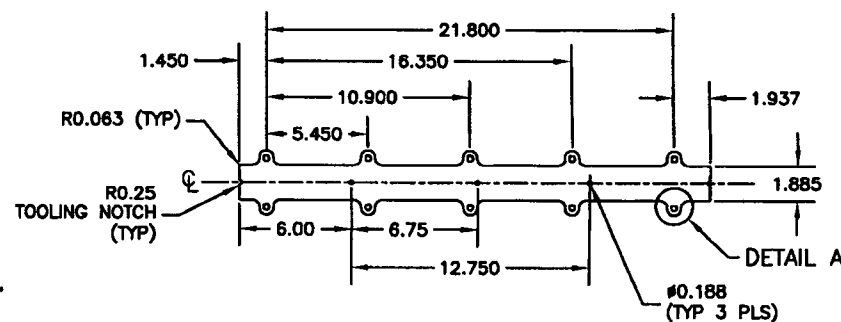
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DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET	3 OF 7	
		REV.	B	



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

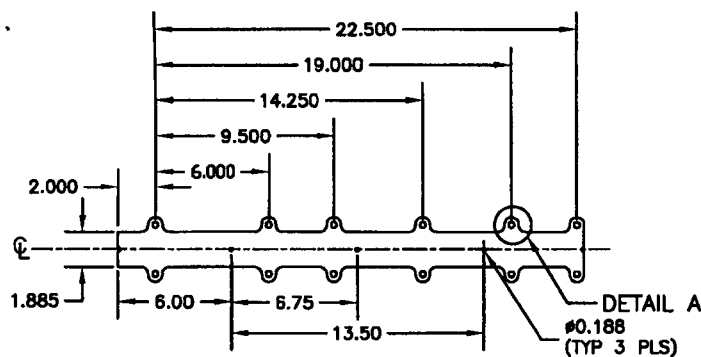
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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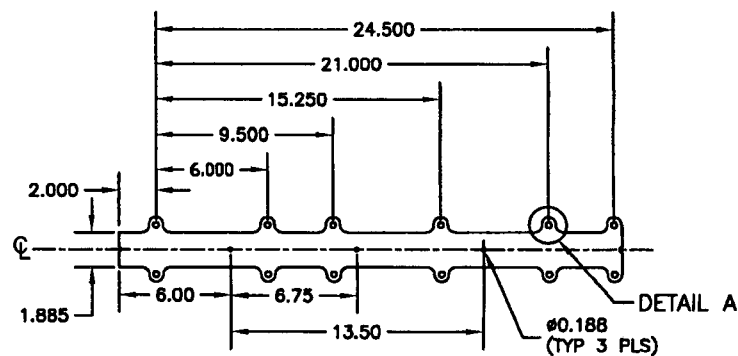
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D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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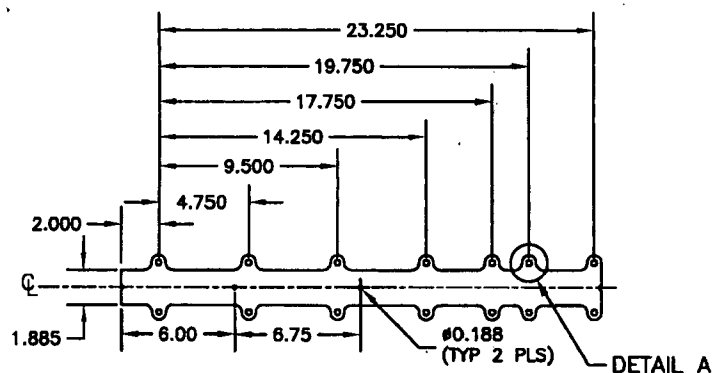
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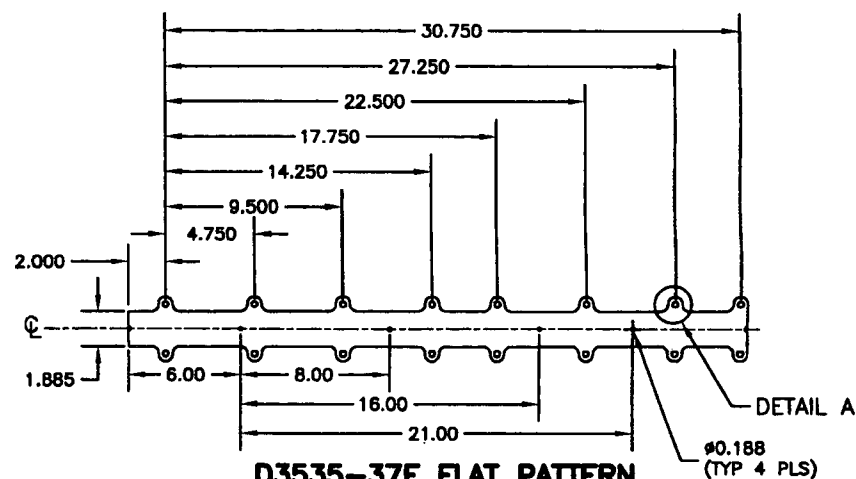
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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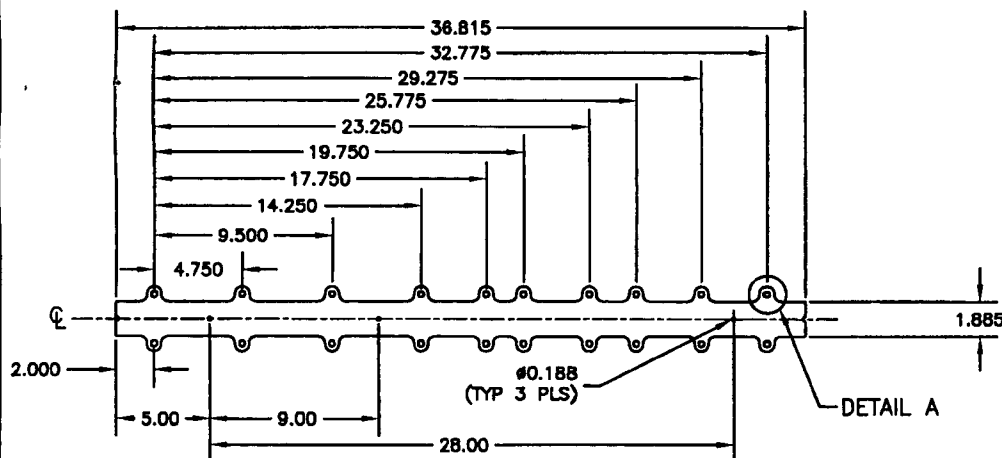
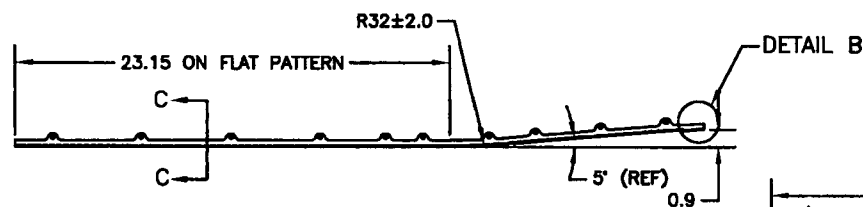
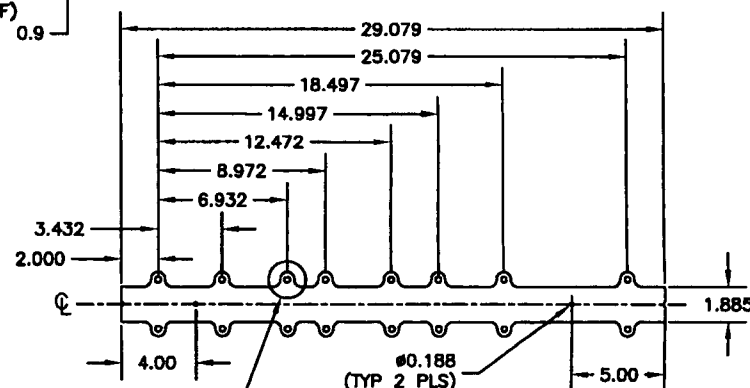
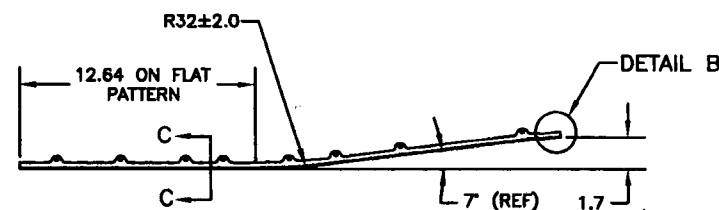
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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

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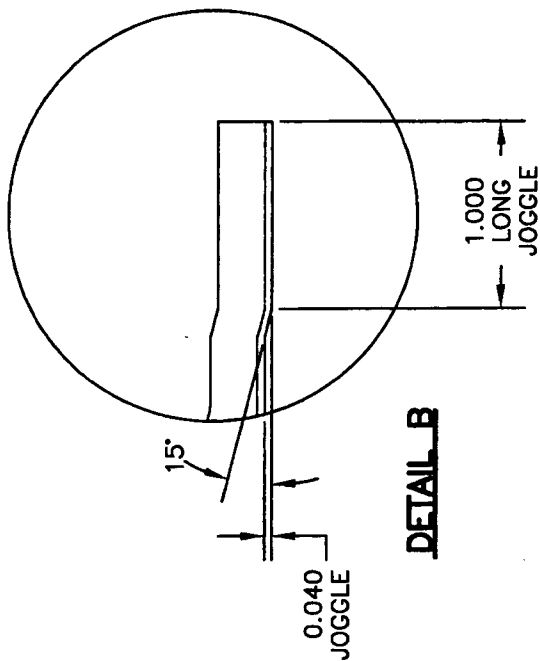


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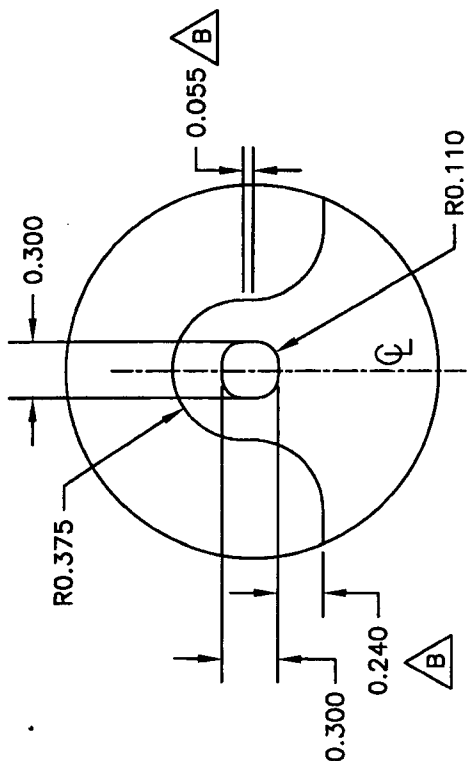
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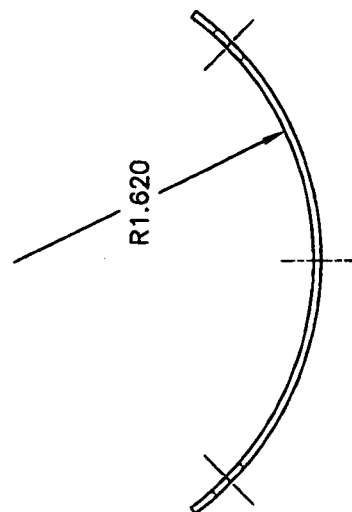
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DETAIL B



DETAIL A



SECTION C-C

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